

# Work Order ID 72076

Tuesday, July 19, 2011 9:55:02 AM

Page 1

Item ID: D4000-7

Accept

Revision ID:

Item Name: Fuel Pickup Fitting

Start Date: 7/20/2011 Start Qty: 8.00

Required Date: 7/27/2011 Req'd Qty: 8.00

Reference:

Approvals: Process Plan: UMF Date: 11-07-19 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Setup Start

Stop

Run Start

Stop

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D4000    | A            |

100 0.00



Doosan

Doosan Lathe

Memo

Turn as per DWG and Folio Fa905

Folio Rev: N/A

Dwg Rev: 8

\*\*USE DIE TO TEST THREADS ON PARTS\*\*

Deburr

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

SA 11/7/27

SA 11/7/27

2/8

2/8

Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: D4000-7 PAR #: 72076 Fault Category: machinery NCR: Yes No DQA:   Date: 11.08.09  
11-756 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed Date: 11/08/10

| NCR: <u>72076</u> |             | WORK ORDER NON-CONFORMANCE (NCR) <u>&amp; 27.32</u>   |                                  |   |                |                               |                       |                          |
|-------------------|-------------|---|----------------------------------|---|----------------|-------------------------------|-----------------------|--------------------------|
| DATE              | STEP        | Description of NC<br>Section A  | Corrective Action Section B      |   |                | Verification<br>Section C     | Approval<br>Chief Eng | Approval<br>QC Inspector |
|                   |             |   | Initial<br>Chief Eng             | Action Description<br>Chief Eng   | Sign &<br>Date |                               |                       |                          |
| <u>11/08/09</u>   | <u>#100</u> | <u>Found At inspection that the 1/4 NPT threaded hole is on a slight angle. Re not machined correctly</u> | <u>11.08.09</u><br><u>Q51042</u> | <u>Qty 15 SCRAP + destroy</u><br><u>no replace</u><br><u>close who for 2nd x2</u> | <u>11/8/3</u>  | <u>B.A</u><br><u>11/08/03</u> | <u>11.08.03</u>       | <u>u10267</u>            |
|                   |             | <u>LOA</u>  |                                  |   |                |                               |                       |                          |
|                   |             |   |                                  |   |                |                               |                       |                          |

NOTE: Date & initial all entries

**Work Order ID 72076**

Tuesday, July 19, 2011 9:55:02 AM



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Item ID: D4000-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Fuel Pickup Fitting

Start Date: 7/20/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/27/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

H.A 11/08/03

2

(X6)

130

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

11/8/4

(20)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/08/04

11-08-4 (8)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, July 19, 2011 9:55:00 AM

Page 1

Work Order ID: 72076



Parent Item: D4000-7



Parent Item Name: Fuel Pickup Fitting

Start Date: 7/20/2011

Required Date: 7/27/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: Ipp Rev:A New Issue 10-01-28 JLM Verified By:EC IPP rev B 10.05.13  
ecn10-562 EC verified by:DD

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M6061T6R1.500

Purchased

No

100

f

9.9970

0.131

1.048



SA 6/27/27

6061-T6 Round Bar 1.50

Location

Loc Qty

Loc Code

MAT013

9.997

110167

9.997

1.2 Pt

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

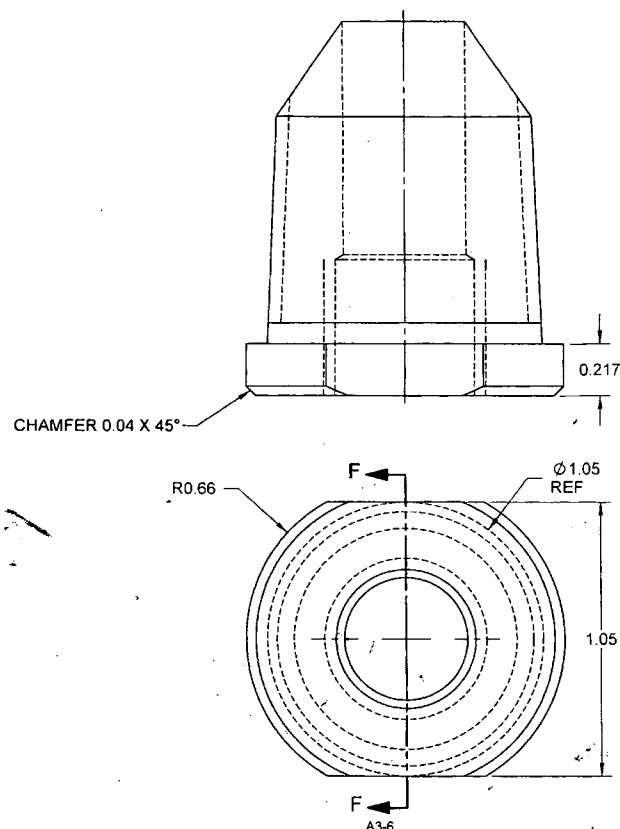
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

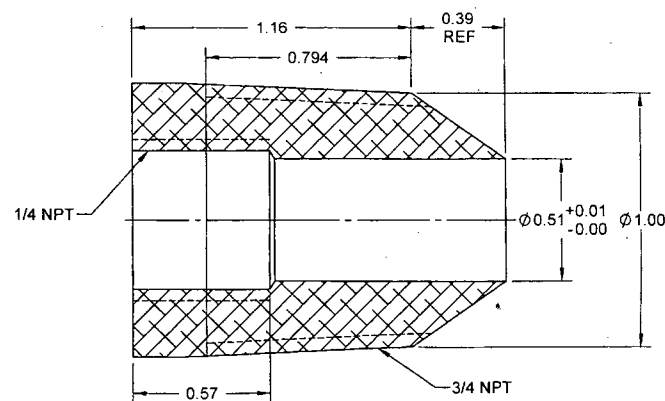
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

| DART AEROSPACE<br>PART NUMBER | JOHN CAMERON AVIATION<br>PART NUMBER |
|-------------------------------|--------------------------------------|
| D4000-7                       | REF JCA-M47-1-10                     |



72076



SECTION F-F  
A6-6

D4000-7 FUEL PICK UP FITTING

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF DART SPEC M6061T6R
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.10 lbs

|            |          |  |              |
|------------|----------|--|--------------|
| DESIGN     |          | <b>DART AEROSPACE LTD</b>  |              |
| DRAWN      |          | HAWKESBURY, ONTARIO, CANADA  |              |
| CHECKED    |          | DRAWING NO.  | REV. A       |
| MFG. APPR. |          | <b>D4000</b>   | SHEET 6 OF 8 |
| APPROVED   |          | TITLE  | SCALE        |
| DE APPR.   |          | <b>FITTING</b>   | NTS          |
| DATE       | 10.02.10 | COPYRIGHT © 2010 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS<br>NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT<br>WRITTEN PERMISSION FROM DART AEROSPACE LTD. |              |

RELEASED  
2010-05-05  
JMT

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



|   |               |                             |
|---|---------------|-----------------------------|
| <b>DART AEROSPACE LTD</b>               |               | <b>Work Order:</b> 72076    |
| <b>Description:</b> Fuel Pickup Fitting |               | <b>Part Number:</b> D4000-7 |
| <b>Inspection Dwg:</b> D4000            | <b>Rev:</b> A | <b>Page 1 of 1</b>          |

### FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension | Tolerance       | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------------|------------------|--------|--------|----------------------|----------|
| 0.04 x 45°        | +/-0.010 x 0.5° | 0.04 x 45°       | /      |        | SA-S                 |          |
| 0.217             | +/-0.010        | 0.217            | /      |        |                      |          |
| R0.66             | +/-0.030        | 0.659            | /      |        |                      |          |
| Ø1.05             | +/-0.030        | 1.046            | /      |        |                      |          |
| 1.05              | +/-0.030        | 1.046            | /      |        |                      |          |
| 1/4 NPT           | N/A             | 1/4 NPT          | /      |        |                      |          |
| 0.57              | +/-0.030        | 0.57             | /      |        |                      |          |
| 3/4 NPT           | N/A             | 3/4 NPT          | /      |        |                      |          |
| I.O.E. 0.339      | +/-0.071        | 0.340            | /      |        | UP Gauge             |          |
| Ø1.00             | +/-0.030        | 1.00             | /      |        |                      |          |
| Ø0.51             | +0.010/-0.000   | 0.517            | /      |        |                      |          |
| 0.39 REF          | +/-0.030        | 0.39             | /      |        |                      |          |
| 0.794             | +/-0.010        | 0.794            | /      |        |                      |          |
| 1.16              | +/-0.030        | 1.16             | /      |        |                      |          |
|                   |                 |                  |        |        |                      |          |
|                   |                 |                  |        |        |                      |          |
|                   |                 |                  |        |        |                      |          |
|                   |                 |                  |        |        |                      |          |
|                   |                 |                  |        |        |                      |          |
|                   |                 |                  |        |        |                      |          |
|                   |                 |                  |        |        |                      |          |
|                   |                 |                  |        |        |                      |          |
|                   |                 |                  |        |        |                      |          |
|                   |                 |                  |        |        |                      |          |
|                   |                 |                  |        |        |                      |          |
|                   |                 |                  |        |        |                      |          |

|                        |                        |                              |     |
|------------------------|------------------------|------------------------------|-----|
| <b>Measured by:</b> SA | <b>Audited by:</b> B.A | <b>Preliminary Approval:</b> | N/A |
| <b>Date:</b> 11/7/27   | <b>Date:</b> 11/08/03  | <b>Date:</b>                 | N/A |

| Rev | Date     | Change             | Revised by | Approved |
|-----|----------|--------------------|------------|----------|
| A   | 10.08.03 | New Issue          | KJ         |          |
| B   | 11.01.17 | Dimensions revised | KJ         |          |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries